

Date: Wednesday, 2/20/2008 4:20:56 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : R/H LOW PROFILE BASKET BASE ASS'Y
 Job Number : 37523
 Estimate Number : 13171
 P.O. Number :
 This Issue : 2/20/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D3712042
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D3712 U/R
 Drawing Revision : U/R
 Previous Run :
 Material :
 Due Date : 3/10/2008 Qty: 1 Um: Each
 Written By : W
 Checked & Approved By : W
 Comment : Est Rev:A new issue 08-01-30 DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 44.7920 f(s)/Unit Total : 44.7920 f(s)
 304 SQ Tube.75x.75x.065W

1- Cut Ribs as per dwg from 3/4" x 3/4" x 0.065 wall 304/316 SS tubing.

QTY PART NUMBER BATCH

2 D3726-1 M106199

2 D3727-1 M106199 ✓

2 D3734-1 M106199

6 D3735-1 M106199

3 D3739-1 M106199

3 D3740-1 M106199

ADS 21 Bushing * 337663
 2- deburr

Pl 08-03-13

2.0 D23273 Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Spacer Bushing
 batch 336479 ✓

Pl 08-03-13

3.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Mounting Bracket
 batch 336481 ✓

Pl 08-03-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:20:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R/H LOW PROFILE BASKET BASE ASS'Y

Job Number: 37523

Part Number: D3712042

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

D37251

HOOP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HOOP

batch

B37626 ✓

Pl 08.03.13

5.0

D37481

HINGE HALF



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

HINGE HALF

batch

B37305 ✓

Pl 08.03.13

6.0

D31661

Basket Hoop



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Basket Hoop

Batch:

B37324 ✓

Pl 08.03.13

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- take D3166-1 and trim as per dwg D3746 to make D3746-1

2- take D3746-1 and drill holes as per dwg D3646

3- drill holes in both D3727-1 as per dwg D3727

4- take 1x D3735-1 and drill holes as per dwg D3735

5- deburr

6- assemble as per dwg D3712 and weld as per QSI004

Pl 08.03.13

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Pl 08.03.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:20:56 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R/H LOW PROFILE BASKET BASE ASS'Y

Job Number: 37523

Part Number: D3712042

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 08-03-14

10.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 39.9000 sf(s)/Unit Total : 39.9000 sf(s)

Expanded Metal Flat Stainless Steel

Pick:

Qty Part Number Description Batch
38sq.ft M304EX0.75-16F Expanded Metal

Batch
M107316 ✓

Pl 08-03-13

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- cut mesh to fit inside basket base and sides as per dwg D

2- weld mesh as per dwg D3712

Pl 08-03-13

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

NS 08-03-14 ENGINEERING APPROVAL

8 08/03/14

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-03-14

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

FL/M- 08/03/14 ①

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BS 08-03-14 ①

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

MF 08-03-15 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 08/03/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:20:56 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R/H LOW PROFILE BASKET BASE ASS'Y

Job Number: 37523

Part Number: D3712042

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

① 08/03/17

Job Completion



U 08.03.17

POSITIVE RECALL

EFFECTIVE 08.02.21 AUTH 4

RELEASED 10 DATE 06-03-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

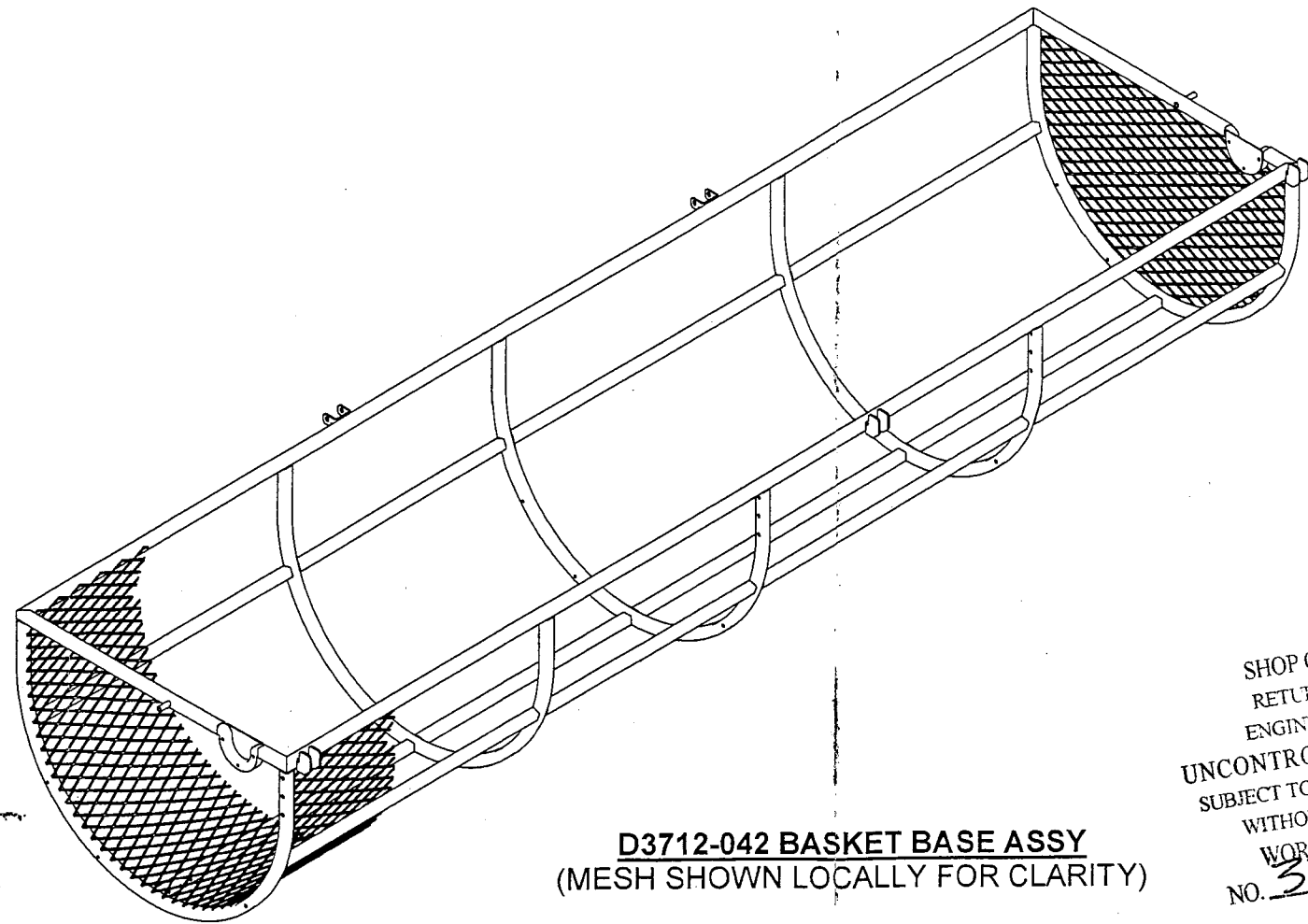
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY. -041	PART NUMBER	DESCRIPTION
X	D3712-042	BASKET BASE ASSY
2	D2327-3	SPACER BUSHING
2	D2581	MOUNTING BRACKET
2	D3725-1	HOOP
2	D3726-1	RIB
2	D3727-1	RIB
2	D3734-1	RIB
5	D3735-1	RIB
1	D3735-3	RIB
3	D3739-1	RIB
3	D3740-1	RIB
1	D3744-1	MESH
1	D3745-1	MESH
1	D3745-3	MESH
1	D3746-1	RIB
1	D3746-3	RIB
2	D3746-5	RIB
1	D3746-7	RIB
3	D3748-1	HINGE HALF
2	D3757-1	BLANKING PLATE
6	AN3-10A	BOLT
12	AN960JD10	WASHER
6	MS21042L3	NUT



D3712-042 BASKET BASE ASSY
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **37523**

PRELIMINARY ISSUE

LE 08.02.15

- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 41.53 lbs
 - 8) WELDING: PER DART QSI 004

A	NEW ISSUE	AJS	08.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	LE	DRAWING NO.	REV. A
MFG. APPR.		D3712	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.	LE	BASKET BASE ASSY	NTS
DATE	08.01.29	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8

7

6

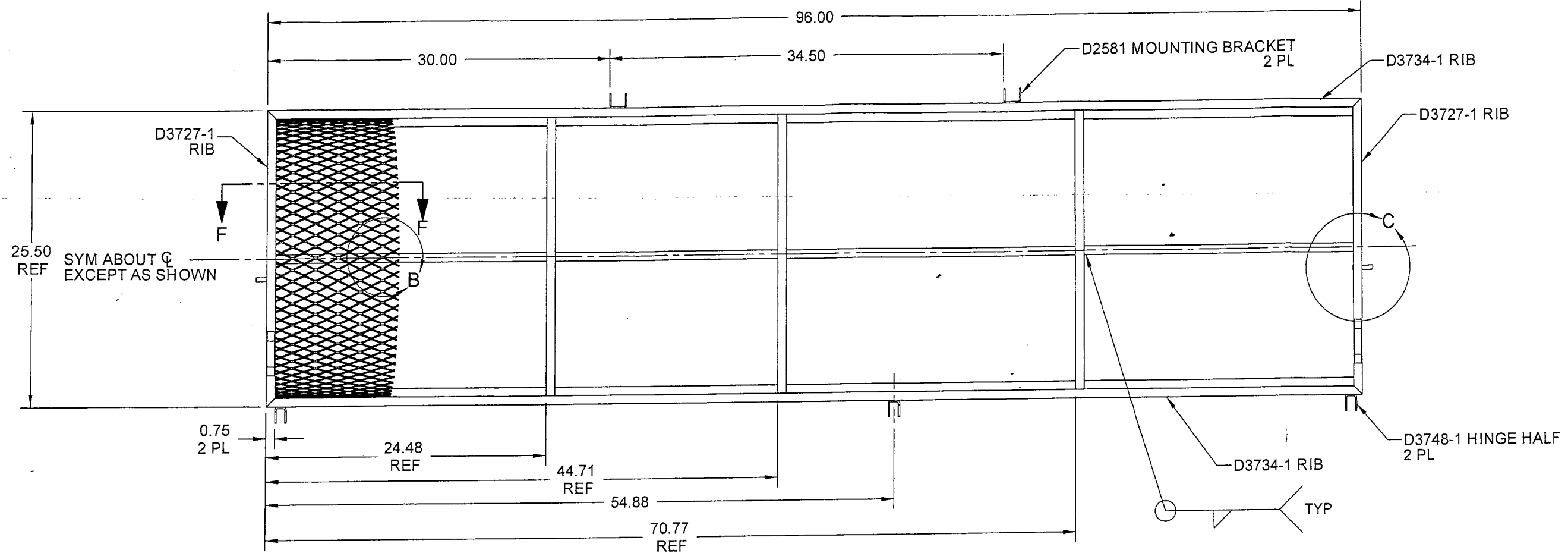
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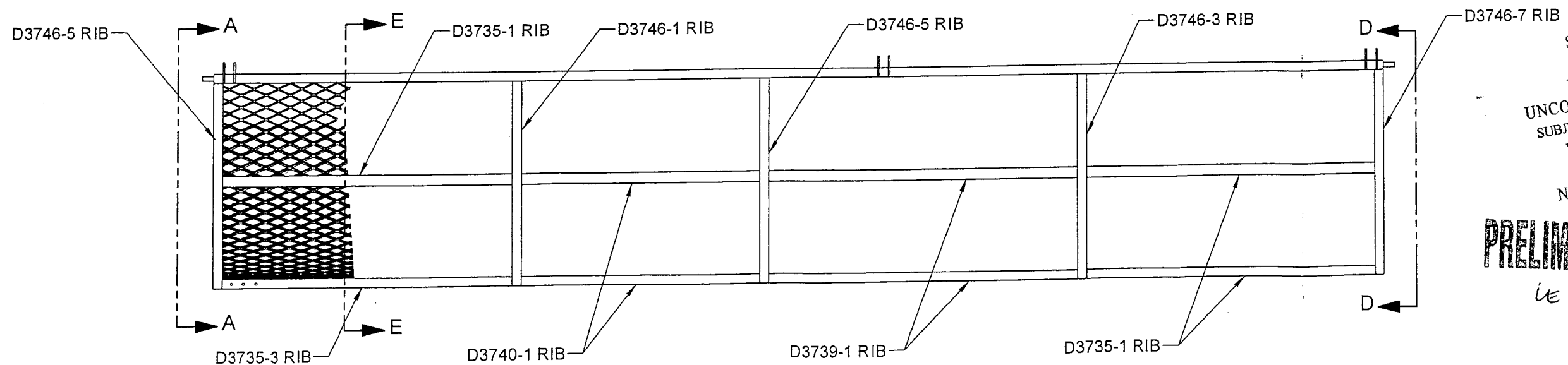
3

2

1



(MESH SHOWN LOCALLY FOR CLARITY)

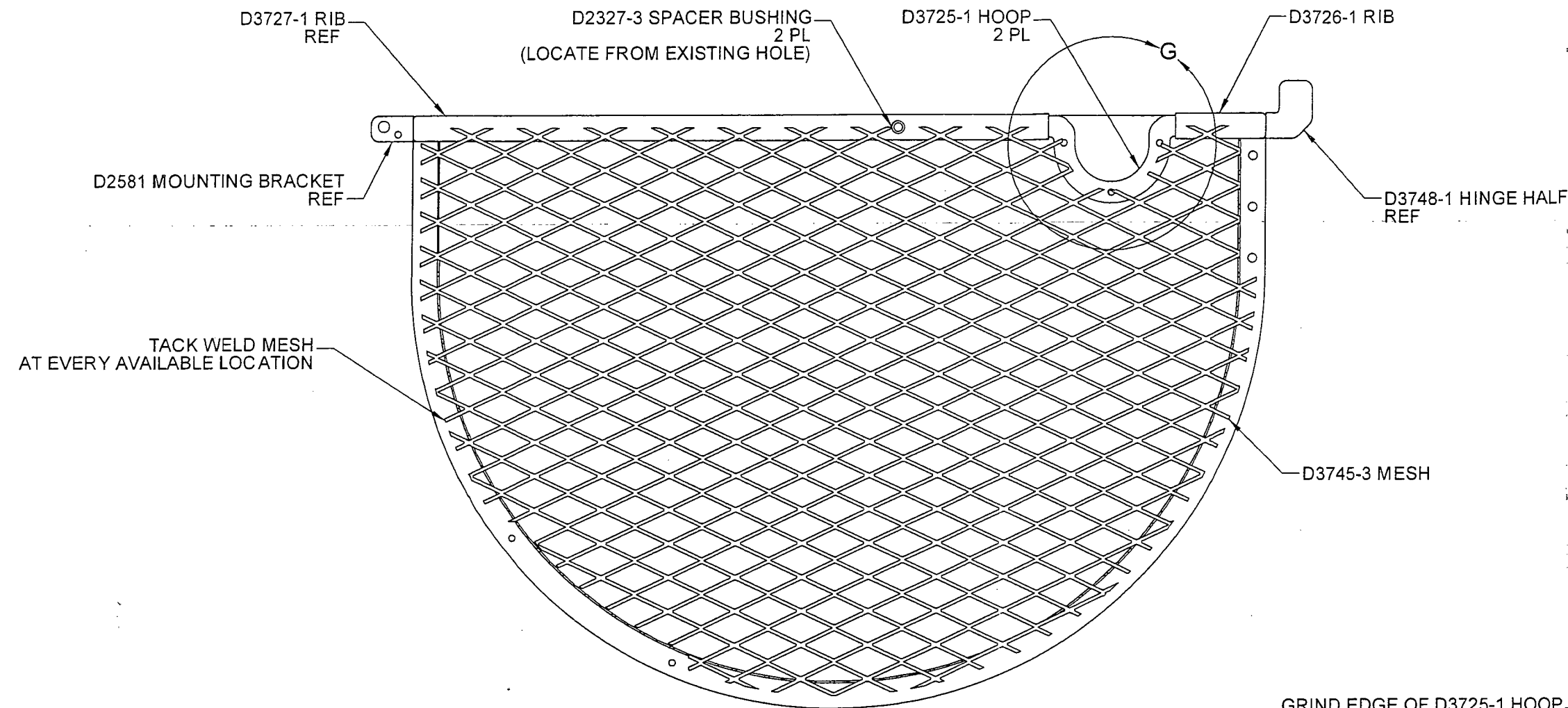
**D3712-041 BASKET BASE ASSY**

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WORK ORDER
NO. 37523

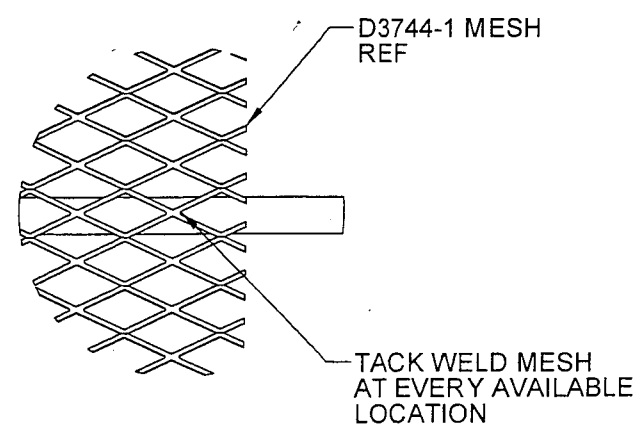
PRELIMINARY ISSUE

UE 08.02.15

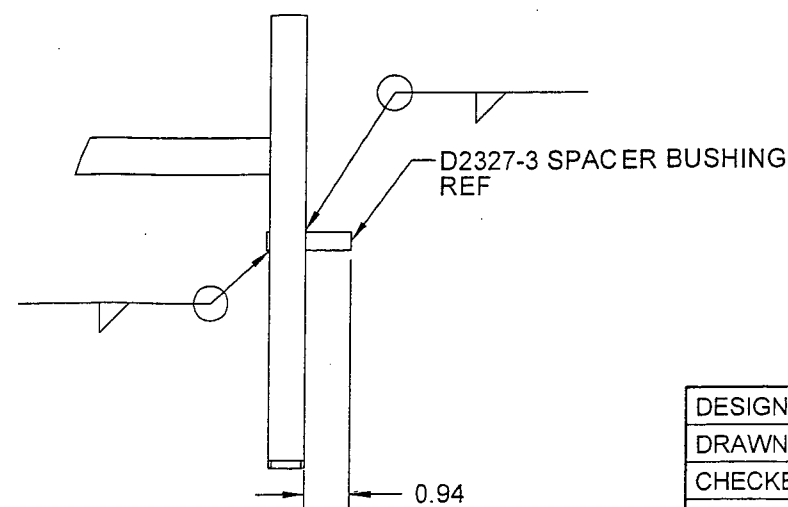
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	UK	DRAWING NO.	REV. A
MFG. APPR.		D3712	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.	UK	BASKET BASE ASSY	1:10
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SECTION A-A
SCALE 1:4

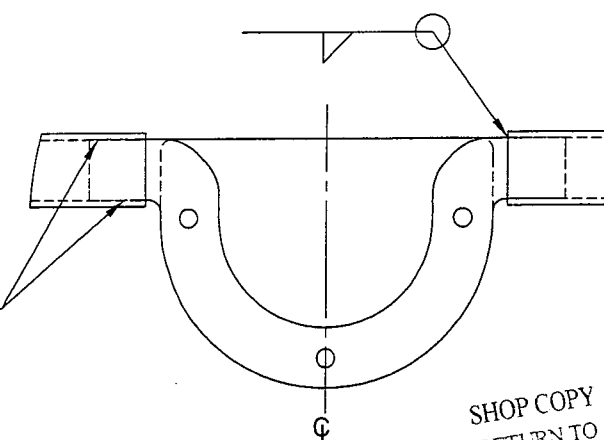


DETAIL B
SCALE 1:4



DETAIL C
SCALE 1:4

GRIND EDGE OF D3725-1 HOOP
LOCALLY AS REQUIRED
ON ASSEMBLY



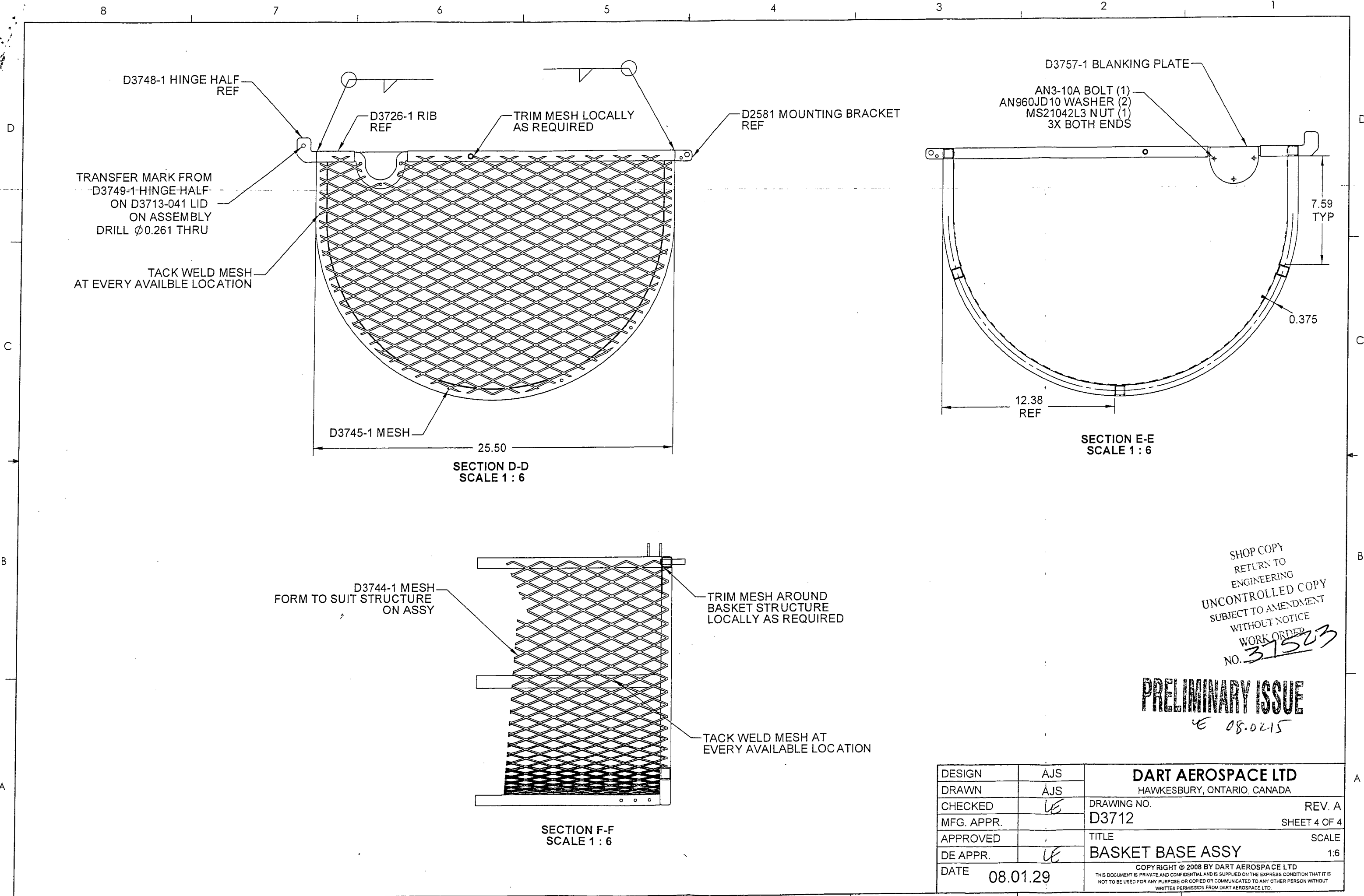
DETAIL G
SCALE 1:2

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WORK ORDER
NO. 37523

PRELIMINARY ISSUE

UE 08.02.15

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DRAWN	AJS		
CHECKED	UE	DRAWING NO. D3712	REV. A
MFG. APPR.			SHEET 3 OF 4
APPROVED		TITLE BASKET BASE ASSY	SCALE 1:4
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DATE	08.01.29		



D3748-1 HINGE HALF
REF

TRANSFER MARK FROM
D3749-1 HINGE HALF
ON D3713-041 LID
ON ASSEMBLY
DRILL $\phi 0.261$ THRU

TACK WELD MESH
AT EVERY AVAILABLE LOCATION

D3726-1 RIB
REF

TRIM MESH LOCALLY
AS REQUIRED

D2581 MOUNTING BRACKET
REF

D3745-1 MESH

SECTION D-D
SCALE 1 : 6

D3757-1 BLANKING PLATE

AN3-10A BOLT (1)
AN960JD10 WASHER (2)
MS21042L3 NUT (1)
3X BOTH ENDS

7.59
TYP

0.375

12.38
REF

SECTION E-E
SCALE 1 : 6

D3744-1 MESH
FORM TO SUIT STRUCTURE
ON ASSY

TRIM MESH AROUND
BASKET STRUCTURE
LOCALLY AS REQUIRED

TACK WELD MESH AT
EVERY AVAILABLE LOCATION

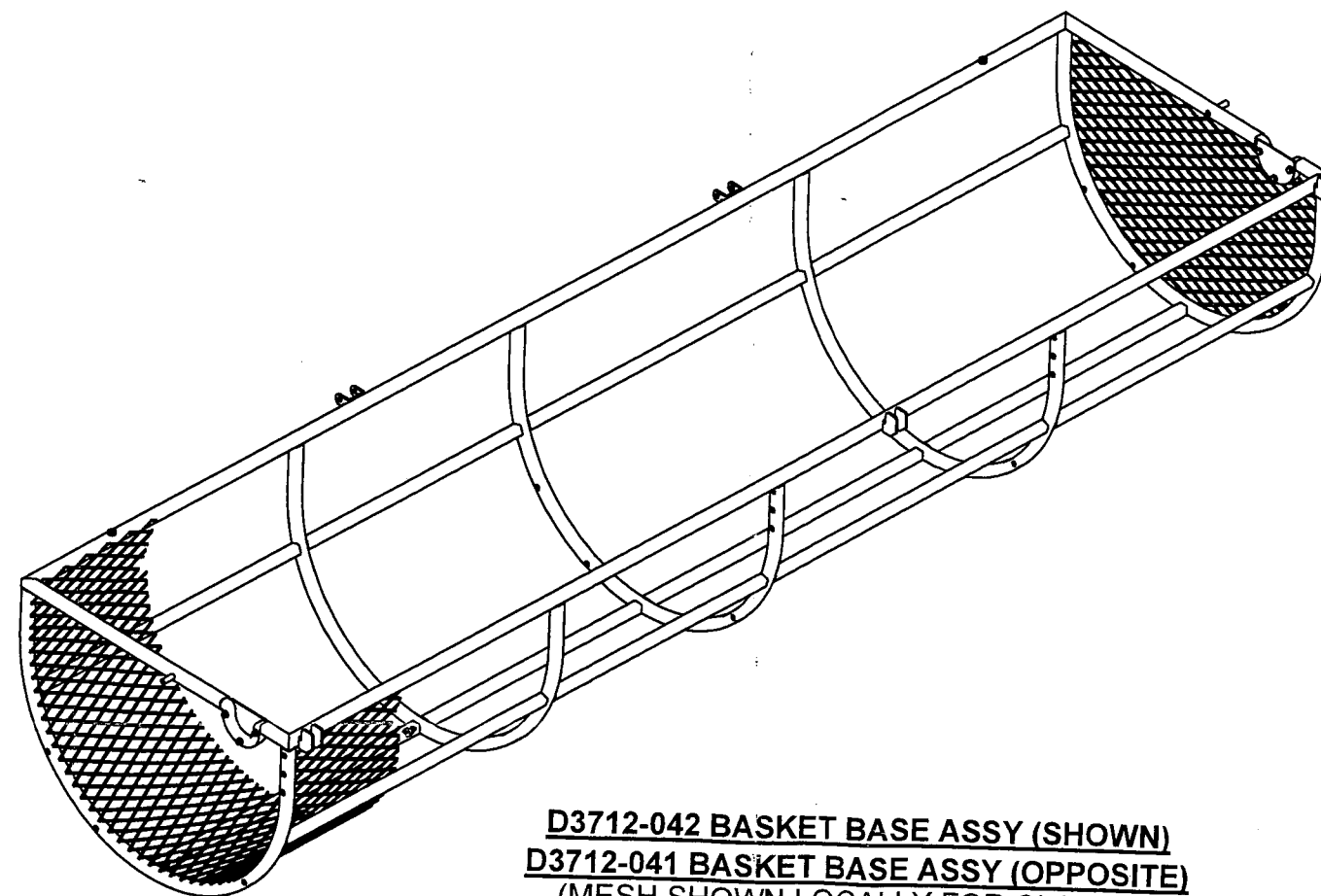
SECTION F-F
SCALE 1 : 6

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WITHOUT NOTICE
WORK ORDER
NO. 31523

PRELIMINARY ISSUE
08.02.15

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	UE	DRAWING NO. D3712	REV. A
MFG. APPR.			SHEET 4 OF 4
APPROVED		TITLE BASKET BASE ASSY	SCALE 1:6
DE APPR.	UE		
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QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3712-041	BASKET BASE ASSEMBLY
	X	D3712-042	BASKET BASE ASSEMBLY
2	2	D2327-3 ✓	SPACER BUSHING
2	2	D2581 ✓	MOUNTING BRACKET
2	2	D2931	BUMPER
2	2	D3725-1 ✓	HOOP
2	2	D3726-1 ✓	RIB
2	2	D3727-1 ✓	RIB
2	2	D3734-1 ✓	RIB
5	5	D3735-1 ✓	RIB
1	1	D3735-3 ✓	RIB
3	3	D3739-1 ✓	RIB
3	3	D3740-1 ✓	RIB
1	1	D3744-1 ✓	MESH
1	1	D3746-1 ✓	RIB
1	1	D3746-3 ✓	RIB
2	2	D3746-5 ✓	RIB
1	1	D3746-7 ✓	RIB
3	3	D3748-1 ✓	HINGE HALF
2	2	D3757-1	BLANKING PLATE
21	21	D3759-1 ✓	BUSHING
6	6	AN3-11A ✓	BOLT
2	2	AN960JD8 ✓	WASHER
12	12	AN960JD10 ✓	WASHER
2	2	MS20600AD4W3 ✓	RIVET
6	6	MS21042L3 ✓	NUT

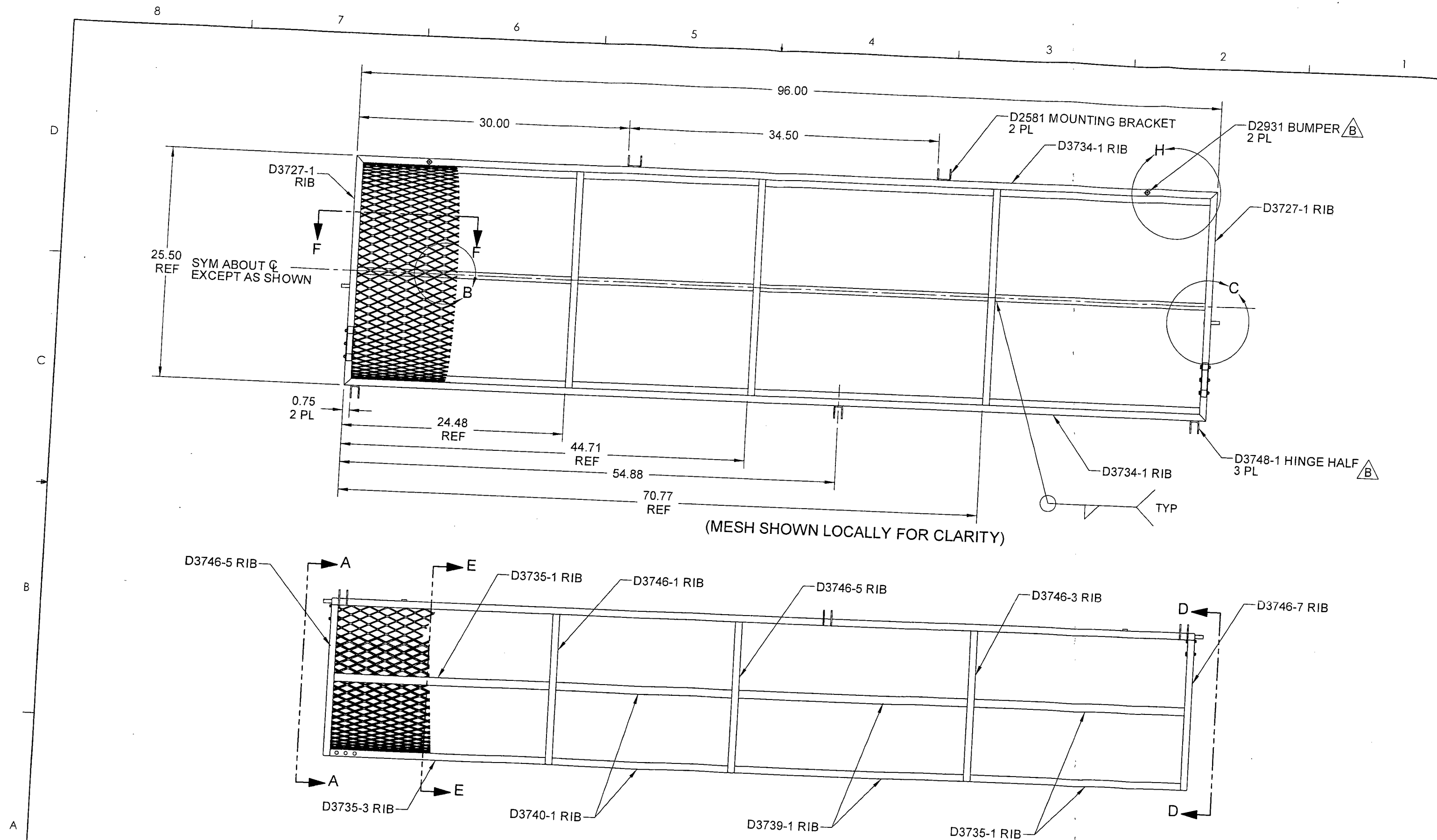


D3712-042 BASKET BASE ASSY (SHOWN)
D3712-041 BASKET BASE ASSY (OPPOSITE)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

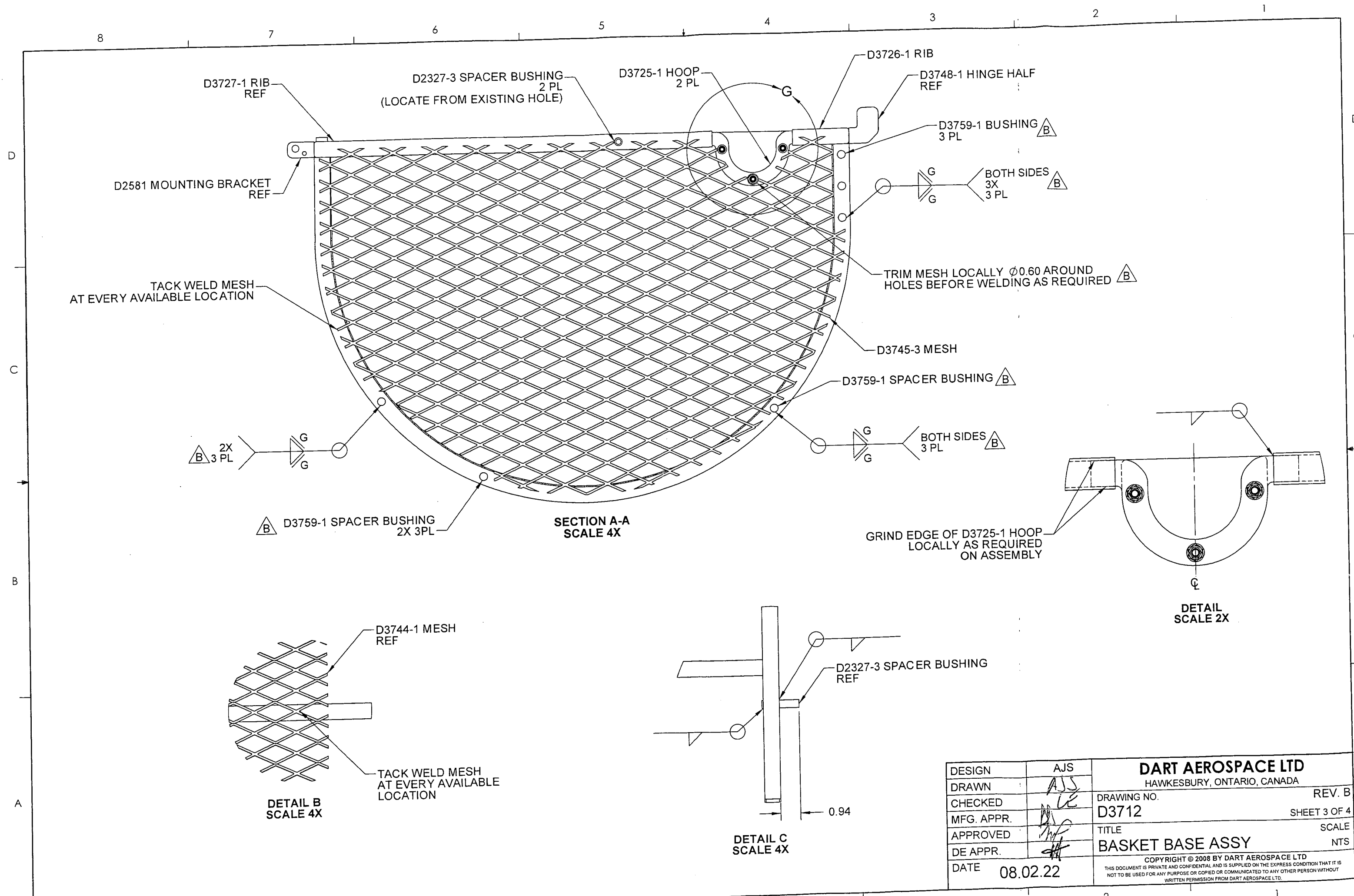
- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) MASK ALL HOLES PRIOR TO POWDER COATING.

B	ADDED-041 ASSEMBLY. WEIGHT WAS 41.50 lbs. ADDED D2931 BUMPER & HARDWARE & D3759-1 BUSHINGS. SHEET 2 ZONE C2 QTY FOR D3748-1 WAS 2. SHEET 4 ADDED DETAIL H. SHEET 3 ZONE C3 & SHEET 4 ZONE C4. ADDED MESH TRIMMING INSTRUCTIONS. SHEET 4 ZONE D2 AN3-11A BOLT WAS AN3-10A P/L UPDATED ACCORDINGLY.	AJS	08.02.22
A	NEW ISSUE	AJS	08.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	CE	DRAWING NO.	REV. B
MFG. APPR.	DS	D3712	SHEET 1 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	BASKET BASE ASSY	NTS
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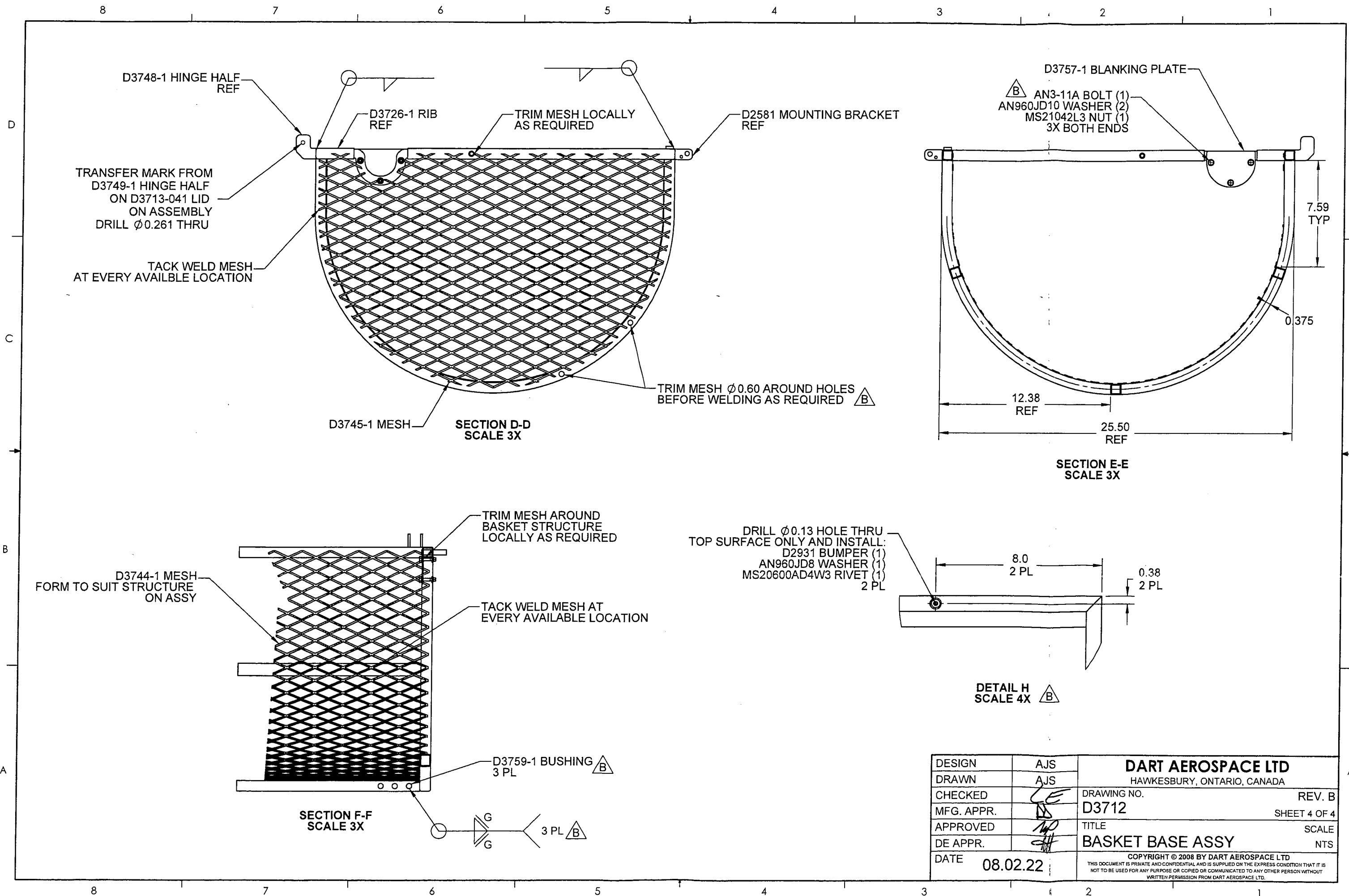


9 D3712-041 BASKET BASE ASSY (OPP)
 9 D3712-042 BASKET BASE ASSY (SHOWN)

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ASS		
CHECKED	CE	DRAWING NO.	REV. B
MFG. APPR.	MP	D3712	SHEET 2 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	BASKET BASE ASSY	



DESIGN	AJS	DART AEROSPACE LTD	
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CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	MP	D3712	SHEET 3 OF 4
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CHECKED	<i>CE</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>DS</i>	D3712	SHEET 4 OF 4
APPROVED	<i>AP</i>	TITLE	SCALE
DE APPR.	<i>CH</i>	BASKET BASE ASSY	NTS
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